

Work Order ID 56565

*Monday, March 01, 2010 2:43:39 PM



Page 1

Item ID: D205-634-041

Accept



Setup Start



Revision ID:

Item Name: Replacement Skidtube

Stop



Start Date: 3/2/2010 Start Qty: 1.00



Required Date: 3/15/2010 Req'd Qty: 1.00

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: *mf*

Date: *10-3-01*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2580	Rev D

100	DOCUMENT CONTROL	0.00							
DC	Memo	0.00							
Document Control	Photocopy D205-634 bluefile & type labels per PPP D205-634-041 CHG002								

N/A

110	BENDING MACHINE - SKIDTUBES	0.00							
CNC Bend 1	Memo	0.00							
CNC Delta 100 Bender	1-Bend as per program D2580.C on CNC Bender and Folio FT009								
	2-Cut tubes as per Dwg. D2580								

10-3-3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

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Item ID: D205-634-041

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Setup Start



Revision ID:

Stop



Item Name: Replacement Skidtube

Start Date: 3/2/2010 Start Qty: 1.00



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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

0.00



Skidtubes

Memo

0.00

1- Deburr ends

2- C'sink holes as per dwg without cutting fluid

3- Prepare tube for welding, remove alodine as required.

4- Scribe batch number insied aft end of tube.

130

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

Handwritten notes and signatures: A large blue checkmark, a signature, and the date '10-3-3' are visible. Below the signature, the date '8 10/02/07' is written. To the right, there is a circled '40'.

W/O:		WORK ORDER CHANGES					
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Stop



Required Date: 3/15/2010 Req'd Qty: 1.00

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Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

140



Skidtubes

Skidtubes

Memo

0.00

1-Weld step D2576 as per Dwg. D2580 and QSI 004
A/R Aluminum Rod

M113207

BE 10/03/03

2-Prep per QSI 005 and weld crossbolt spacers D2579 as per Dwg. D2580, QSI 004.

For D2579 spacers, weld one side, pass 3/8" drill, weld other side, pass 3/8" drill
A/R Aluminum Rod

M113207

BE 10/03/03

3-Grind welds as per Dwg D2580 Grind flush ridge made from bending

4-Drill holes for wearplates using DT 8217 & DT8937 Open holes to 19/64",
adjust stopper not to hit web. Deburr

5-Counterbore crossbolt spacers to 7/16" ID x 1.0" deep as per Dwg D2580.
Deburr holes

6-Drill pilot holes for aft cap using DT 8215 Open holes to 0.208". Deburr

7-Drill pilot holes for Tow ring using DT8091, open to .640" and Deburr

BE 10/03/04

W/O:		WORK ORDER CHANGES					
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Run

Start

QC:

Date:

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Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150



QC

Quality Control

QC10- Inspect visual per QSI004- ground welds

0.00

0.00

Memo

8/10/09/09

(X)

160



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

0.00

Memo

8/10/09/09

(X)

170



HandFinish

Hand Finishing

Pressure Wash per QSI005 4.3

0.00

0.00

Memo

Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch and leave fwd cap out of solution.

pressure-wash

8/10/09/09

(X)

6

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Approvals: Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

180



Powdercoat

Powder Coating

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

Memo

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

0.00

0.00

0.00

0.00

=> 24

10/63/09

(X1)

Ø

190



QC

Quality Control

QC3- Inspect Part Finish

Memo

BR 10-3-10

Ø. Ø.

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Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

200



HandFinish

Hand Finishing

Memo

0.00

1-Install inserts & wearplates & Gaskets as per Dwg. D2580. Use a drop of Sikaflex on insert holes before installing wearplates
A/R ☐ ☐ ☐ Sikaflex-291 M 112345
Sikaflex expire date: 10/08

2-Coat D2594-3 O' rings with Petroleum Jelly and install on D2594-1 plugs as per Dwg D2580

3-Inspect for foreign object per QSI 024

4-Install 2855 Aft Cap as per Dwg D2580 and seal Fwd Step & Aft Cap with Sikaflex. Clean excess adhesive
A/R ☐ ☐ ☐ Sikaflex-291 M 112345
Sikaflex expire date: 10/08

5-Wing Walk as per Dwg D2580 and QSI 005 4.4
Batch: M 113462

10-3-10

①

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Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

210



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

Inspect Aft Cap, Fwd Step and Wing Walk of work to Current Step Inspect for Foreign objects per QSI 024

220



Packaging

Packaging

Packaging

0.00

Memo

0.00

Identify and pack for shipping as per PPPD205-634-041

Location:

PPP Rev:

PPD 56404

230



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

Rec'd 3/11

10/03/16

MF

10-3-11

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 IPP Rev. O 06.02.28 Added paperwork EC
 IPP Rev:P 07-07-09 SS Wearplates & Gaskets JLM

Start Date: 3/2/2010

Required Date: 3/15/2010

Start Qty: 1.00

Required Qty: 1.00

D2580-1



205 Skidtube bent detail

Manufactured No 110 Each 4.0000 1.0000



Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

LG B56121

4

①

DP 10-3-3

54541

2

56123

2

D2576-3



Step (maching detail)

Manufactured No 140 Each 132.0000 1.0000



Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

132

46661

85

52215

47

1 8E 10/03/03

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 IPP Rev:P 07-07-09 SS Wearplates & Gaskets JLM

Start Date: 3/2/2010

Required Date: 3/15/2010

Start Qty: 1.00

Required Qty: 1.00

D2579



Crossbolt Spacer

Manufactured No 140 Each 216.0000 20.0000



<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
LG	94	
51525	4	
53780	3	
54543	18	
56145	69	
Main Warehouse		
ST	122	
43988	4	
46434	4	
46956	2	
47797	9	
48272	2	
51314	71	
51315	30	

20

86 10/03/03

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Page 2

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Start Date: 3/2/2010

Required Date: 3/15/2010

Start Qty: 1.00

Required Qty: 1.00

D2855



Cap

Manufactured No 200 Each 149.0000 1.0000



<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST026	149	
50513	1	
50770	1	
51539	37	
53791 ✓	110	

AN3-5A



Bolt

Purchased No 200 Each 1,431.000 2.0000



<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	1431	
100188	188	
105057 ✓	1243	

1 OK 10-3-10.

2 OK 10-3-10.

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Page 3

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Start Date: 3/2/2010

Required Date: 3/15/2010

Start Qty: 1.00

Required Qty: 1.00

AN960JD10L



Washer

Purchased No 200 Each 3,197.000 2,0000



Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST	3197	
101291	16	
105793	49	
110985 ✓	3132	

ALS7-1032-130



Insert

Purchased No 200 Each 986.0000 50,0000



Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST	986	
108606	52	
111529	130	
111779	34	
112772	11	
113238	759	

ALS4-1032-130.

2 BR 10-3-10

50 BR 10-3-10.

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 IPP Rev. O 06.02.28 Added paperwork EC
 IPP Rev:P 07-07-09 SS Wearplates & Gaskets JLM

Start Date: 3/2/2010

Required Date: 3/15/2010

Start Qty: 1.00

Required Qty: 1.00

AN3C4A



BOLT

Purchased No 200 Each 1,033.000 50.0000



Warehouse Loc Qty Loc Code
Location

Main Warehouse
 ST 114103 1033
 112314 13
 112720 12
 112724 3
 112829 1
 112991 2
 113121 64
 113226 344
 113749 394
 113749 200

13 pr 10-3-10

AN960C10L



washer

Purchased No 200 Each 388.0000 50.0000



Warehouse Loc Qty Loc Code
Location

NAS 1149C0832R OFFSHORE 113737
 FG 100
 103585 100
 Main Warehouse
 ST 288
 112116 128
 112612 160

50. pr 10-3-10

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Start Date: 3/2/2010

Required Date: 3/15/2010

Start Qty: 1.00

Required Qty: 1.00

D3566-13



Gasket

Manufactured No 200 Each 79.0000 1.0000



Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
FP	77	
53461 ✓	77	
Main Warehouse		
ST	2	
45717	1	
50265	1	

1 Bk 10-3-10.

D3566-5



Gasket

Manufactured No 200 Each 31.0000 1.0000



Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
FP19	27	
55026 ✓	15	
55335	12	
Main Warehouse		
ST	4	
36113	1	
46186	1	
47318	1	
51260	1	

1 Bk 10-3-10

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Start Qty: 1.00

Required Qty: 1.00

D3566-1



Gasket

Manufactured No 200 Each 33.0000 2.0000



Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
FP	28	
52512	3	
54480	1	
55011	1	
55320 ✓	23	
Main Warehouse		
ST	5	
46349	1	
51218	1	
51259	3	

2 BR 10-3-10

D3564-11



Wearshoe

Manufactured No 200 Each 16.0000 1.0000



Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
FP19	14	
52125	2	
55332 ✓	12	
Main Warehouse		
ST	2	
45823	1	
50112	1	

1 BR 10-3-10

Monday, March 01, 2010 2:43:39 PM

Shop Packet Print

Page 7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Monday, March 01, 2010 2:43:39 PM

Page 8

Work Order ID: 56565

Parent Item: D205-634-041

Parent Item Name: Replacement Skidtube

Comments: IPP Rev:N 02.08.28 FP was QC5 in Step 27; Added QC5 to Step 30 KJ
 IPP Rev P 10.02.19 per PAR09-043 EC verified by:DD
 IPP Rev. O 06.02.28 Added paperwork EC
 IPP Rev:P 07-07-09 SS Wearplates & Gaskets JLM

Start Date: 3/2/2010

Required Date: 3/15/2010

Start Qty: 1.00

Required Qty: 1.00

D3564-13



Wearshoe

Manufactured No 200 Each 19.0000 1.0000



Warehouse Loc Qty Loc Code

Location

Main Warehouse

FP17 56285

7

51611

7

Main Warehouse

ST

12

45409

2

46495

10

1 Bl 10-3-10.

D3564-9



Wearshoe

Manufactured No 200 Each 25.0000 1.0000



Warehouse Loc Qty Loc Code

Location

Main Warehouse

FP19

23

55025 ✓

11

55334

12

Main Warehouse

ST

2

44659

1

45825

1

1 Bl 10-3-10.

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Page 8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 9

Work Order ID: 56565



Parent Item: D205-634-041



Parent Item Name: Replacement Skidtube

Start Date: 3/2/2010

Required Date: 3/15/2010

Comments: IPP Rev:N 02.08.28 FP was QC5 in Step 27; Added QC5 to Step 30 KJ
IPP Rev P 10.02.19 per PAR09-043 EC verified by:DD
IPP Rev. O 06.02.28 Added paperwork EC
IPP Rev:P 07-07-09 SS Wearplates & Gaskets JLM

Start Qty: 1.00

Required Qty: 1.00

D3564-5

Manufactured No

200

Each

41.0000

1.0000



Wearshoe

Warehouse

Loc Qty

Loc Code

Location

OFFSHORE

FG

2

34806

2

Main Warehouse

FP19

37

51925

1

54772 ✓

11

55024

12

55333

13

Main Warehouse

ST

2

45824

1

47433

1

1 Bk 10-3-10

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Page 9

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Monday, March 01, 2010 2:43:39 PM

Page 10

Work Order ID: 56565



Parent Item: D205-634-041



Parent Item Name: Replacement Skidtube

Start Date: 3/2/2010

Required Date: 3/15/2010

Comments:

IPP Rev:N 02.08.28 FP was QC5 in Step 27; Added QC5 to Step 30 KJ
 IPP Rev P 10.02.19 per PAR09-043 EC verified by:DD
 IPP Rev. O 06.02.28 Added paperwork EC
 IPP Rev:P 07-07-09 SS Wearplates & Gaskets JLM

Start Qty: 1.00

Required Qty: 1.00

D2594-3



Manufactured

No

200

Each

628.0000

16.0000



O-Ring, 205 Skidtube

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

FP

527

51613

27

55546 ✓

500

Main Warehouse

ST

101

52562

101

PR 10-3-10.

Monday, March 01, 2010 2:43:39 PM

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Page 10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Picklist Print

Monday, March 01, 2010 2:43:39 PM

Page 11

Work Order ID: 56565

Parent Item: D205-634-041

Parent Item Name: Replacement Skidtube

Comments: IPP Rev:N 02.08.28 FP was QC5 in Step 27; Added QC5 to Step 30 KJ
 IPP Rev P 10.02.19 per PAR09-043 EC verified by:DD
 IPP Rev. O 06.02.28 Added paperwork EC
 IPP Rev:P 07-07-09 SS Wearplates & Gaskets JLM

Start Date: 3/2/2010

Required Date: 3/15/2010

Start Qty: 1.00

Required Qty: 1.00

D2594-1

Manufactured No

200

Each

689.0000

16.0000



Plug, 205 Skidtube



Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

FP

561

54008

1

54643

15

55002 ✓

545

Main Warehouse

ST

128

42221

16

42807

92

43884

3

46435

2

51527

9

51757

6

16. Bk 10-3-10.

Monday, March 01, 2010 2:43:39 PM

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Page 11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2580	REV. D SHEET 1 OF 3
DATE 07.02.27		TITLE 205 SKIDTUBE ASSEMBLY	SCALE NTS
A	96.09.16	NEW ISSUE	
B	96.12.02	AS MANUFACTURED	
C	98.08.26	REDRAWN, INCLUDED DEO 9094/9097	
D	07.02.27	CHANGE TO SS WEARPLATES AND GASKETS, INCLUDE DEO 9124/9183	

RELEASED
07.06.28 *[Signature]*

QTY -041	QTY -045	Part Number	Description
X		D2580-041	SKIDTUBE ASSEMBLY
	X	D2580-045	SKIDTUBE ASSEMBLY
1	1	D2500-1-190	EXTRUSION
1	1	D2576-3	STEP
20	24	D2579	CROSS BOLT SPACER
16	16	D2594-1	PLUG
16	16	D2594-3	O-RING
1	1	D2596	205 WEB
1	1	D2855	AFT CAP
1	1	D3564-5	WEARSHOE
1	1	D3564-9	WEARSHOE
1	1	D3564-11	WEARSHOE
1	1	D3564-13	WEARSHOE
2	2	D3566-1	GASKET
1	1	D3566-5	GASKET
1	1	D3566-13	GASKET
50	50	ALS7-1032-130 or AKS7-1032-130 or AKS4-1032-130 or AELS-1032-130	INSERT
50	50	AN3C4A	BOLT
2	2	AN3-5A	BOLT
50	50	AN960C10L	WASHER
2	2	AN960JD10L	WASHER

#56565

GENERAL NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) ALL DIMENSIONS ARE IN INCHES
- 3) INSERT D2596 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241 ADHESIVE PER DART QSI 015 BEFORE BENDING. ENSURE HOLES LINE-UP.
- 4) BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF 60 AND ENDING WITH A MINIMUM RADIUS OF 30. A MAXIMUM REDUCTION OF 0.200 IN DIAMETER IS ALLOWABLE IN THE BENT PORTION OF THE TUBE.
- 5) USE DART DRILL TEMPLATE TD2577-205 TO LOCATE AND DRILL \varnothing 0.297 HOLES FOR WEARSHOE INSERTS. INSTALL ALS7-1032-130 PER SECTION D-D (50 PLACES) AFTER FINISH. INSTALL AN3C4A BOLTS AND AN960C10L WASHERS WITH SIKAFLEX-241/-291.
- 6) WELDING TO BE DONE PER DART QSI 004.
- 7) FINISH:
SEE NOTES ON
PAGE 2 FOR D2580-041 AND
PAGE 3 FOR D2580-045
- 8) INSERT D2594-1 PLUG C/W D2594-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE) AFTER FINISH (16 PLACES).

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

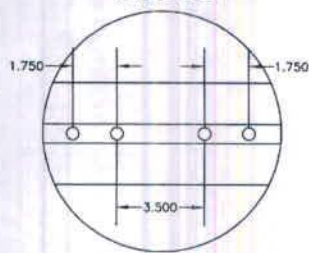
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

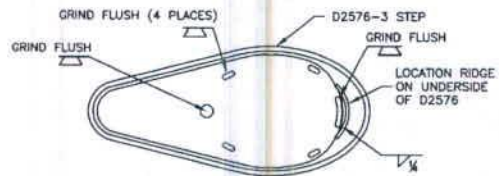
NOTE: Date & initial all entries

DETAIL A
SCALE 5:24

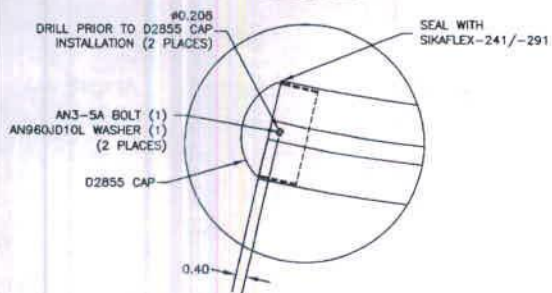


RELEASED
07-06-28-11

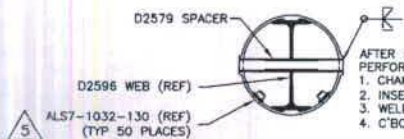
DETAIL B
SCALE 5:24



DETAIL C
SCALE 5:24



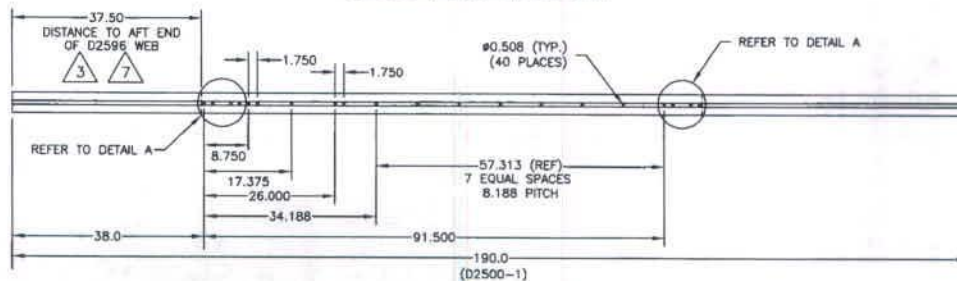
SECTION D-D
SCALE 5:24



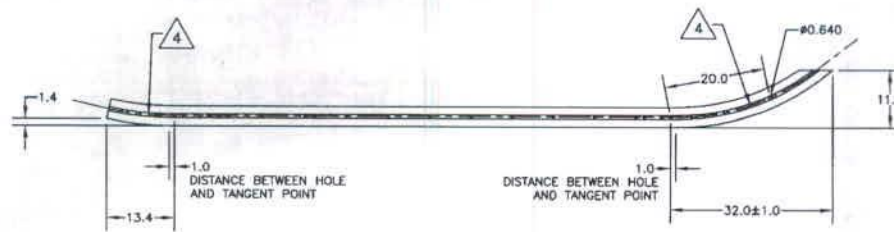
D2580-041 NOTES

- i) FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB POWDER COAT ASSEMBLY GLOSS WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3 BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4

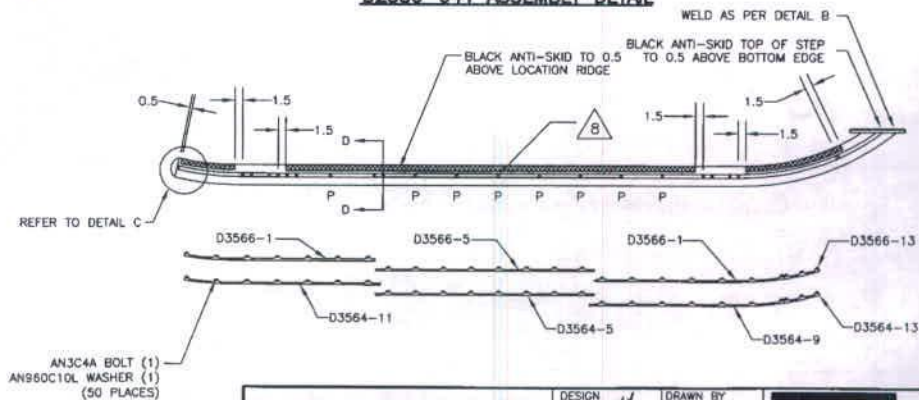
D2580-1 DRILLING DETAIL



D2580-1 BENDING AND CUTTING DETAIL




D2580-041 ASSEMBLY DETAIL



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DESIGN	
CHECKED	
DATE	07.02.27

DRAWN BY	PH
APPROVED	H

DART

DART AEROSPACE LTD.
HARRISBURG, ONTARIO, CANADA

DRAWING NO.	D2580
-------------	-------

REV. D
SHEET 2 OF 3

TITLE
205 SKIDTUBE ASSEMBLY

SCALE

1:24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

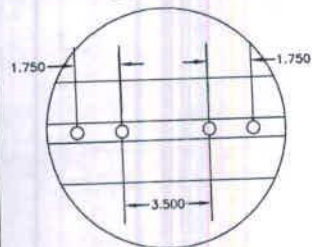
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

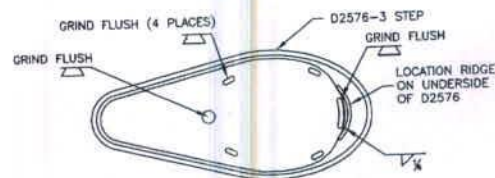
NOTE: Date & initial all entries

DETAIL E
SCALE 5:24

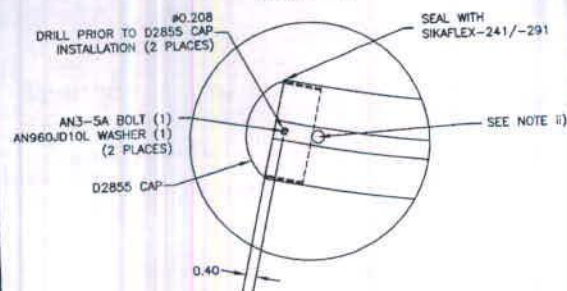


RELEASED
07.06.28

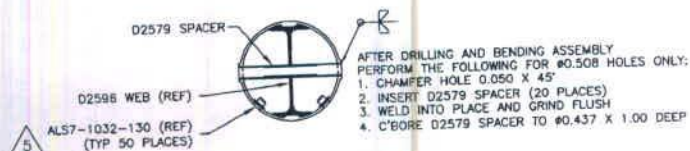
DETAIL F
SCALE 5:24



DETAIL G
SCALE 5:24



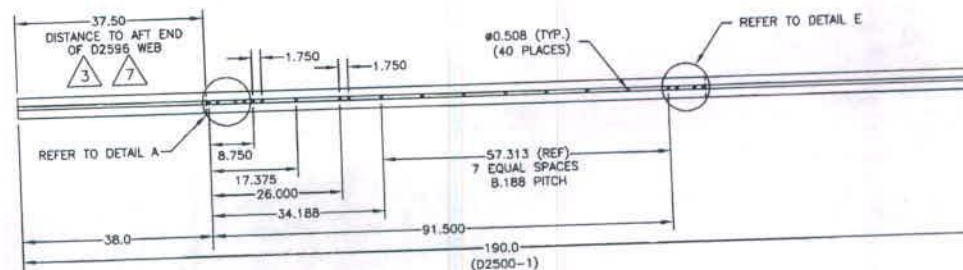
SECTION H-H
SCALE 5:24



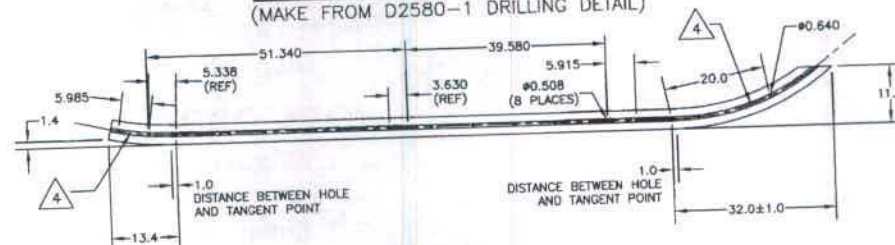
D2580-045 NOTES

- FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB
POWDER COAT ENTIRE ASSEMBLY GREEN (REF. 4.3.5.8) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4
- IT IS ACCEPTABLE TO GRIND A RELIEF IN THE D2855 AFT CAP TO PREVENT INTERFERENCE WITH THE SPACER AT THIS LOCATION

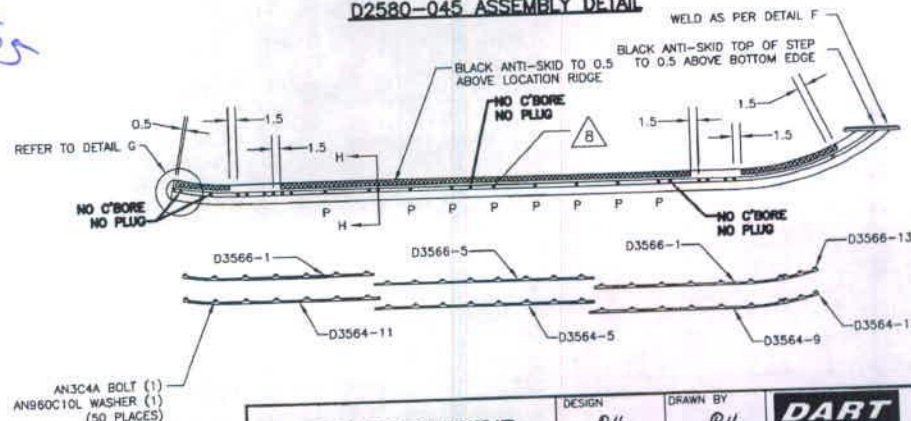
D2580-1 DRILLING DETAIL



D2580-5 BENDING AND CUTTING DETAIL
(MAKE FROM D2580-1 DRILLING DETAIL)



D2580-045 ASSEMBLY DETAIL



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DESIGN RH	DRAWN BY RH	DART	DART AEROSPACE LTD. HAMMERSLEY, ONTARIO, CANADA
CHECKED H	APPROVED H	DRAWING NO. D2580	REV. D SHEET 3 OF 3
DATE 07.02.27	TITLE 205 SKIDTUBE ASSEMBLY	SCALE 1:24	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

NO. 226

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barday Elliott
Job number: 56134
Part number: D205 634-041
Description: 205 skid tube
Welding Process: Tig[☒] Mig[]
Base material: Aluminum
Current: AC[☒] DC[]

TEST REQUIREMENTS AND RESULTS

Visual: pass[☒] fail[]
Penetration: pass[☒] fail[]

UNACCEPTABLE

Cracks: pass[☒] fail[]
Undercut: pass[☒] fail[]
Pin holes: pass[☒] fail[]
Overlap (cold lap): pass[☒] fail[]
Porosity (surface): pass[☒] fail[]
Coloration: pass[☒] fail[]

Qualifier [Signature] Date of Test Coupon 10-02-23

Welder Barday Elliott Date of Test Coupon 10-02-23

The above named individual is qualified in accordance with AWS D17.1.2001 to weld

